Wo	rk O	rder	ID	1210	92

121092

Page 1

June-16-14 1:18	8:11 PM			1(1917					
Revision ID: Item Name:	D3417-5 Washer		Accept		04010	n* s	Setup Start Stop	ı u.	S1* S2*
	7/15/14 Start Qty: 24.00 7/15/14 Req'd Qty: 24.00	*24*		Cust Item 1	ID:				
Required Date: Reference:	7/13/14 Req a Qiy: 24.00	*24*		Customer:					
Approvals:	Process Plan:QC:		Tooling: SPC (Y/N):		ate:		Run Start Stop	*NI *NI	R1*
Sequence ID/ Work Center II	Operation Description	,	Set Up/ Run Hours	Tool ID	Tool # Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3417	Rev F							•••	69-6
1 \\n^ \\ Doosan \text{Lathe}	Hardinge CNC LATHE Memo 1-Turn as po Rev: Dwg D3417	er Folio FA761 &	0.00		A HA	7			**************************************
110 *1,10* QC Quality Control	2-Deburr QC2- Inspect parts off m . Memo	- M	0.00			9	15		68-6 E1 SVO 14-7-16
120 *120* QC Quality Control	QC8- Inspect parts - seco	and check	0.00			9	Ø		DAS 45 9-379 14/08/2

DQA:	2	gw7	Date:	14/08	<u> 8/2/</u>								
	Λ	<u>/</u>		P4/8	ial	WORK ORDER NON	-CO	ONFO	RMANCE / UF				AEROSPACE
QA Closed:	y	 	Date:	1210	120				<u>.</u>	<u>\</u>	/ork Order u	pdate only	
Work Ord	er:	171	097	•		DISPOSITION				AGAINST D	EPARTMENT	/PROCESS	
						Rework]		Skid-tube	Crosstube		Water Jet	Engineering
Part I	Vo.	D39	117-5	2		Scrap 🔨]		Machining 🕺	Small Fab	Pro	d. Eng. Coor.	Quality
		۱,	1111	7		Use-as-is	4	Therr	noforming	Finishing	Rec/Sto	re/Packaging	Other
NCR	No.	14-	414	<u> </u>		Suspected Unapproved]		Large Fab	Composite		Supplier	
Root					Desci	ription of work order update		nitial	Acti	ion	Sign &		
Cause		Date	Step	Qty		or non-conformance	Ch	ief Eng	Descri	iption	Date	Verification	QC Inspector
Design Doc/Data	ķ			15	15,	prite without		DAS	Scrapt De	Jry 1	27	DAS 16	DAS
Equip/Tooling Handling/Pre	<u> </u>	. 21						16			14.8.21	9-89	16 9-89
Material	\vdash	y-8-21	100		<i> </i> - 1	this should marker.		9-89			2/		
Operator		1'			tou	this should	Q5	2042				14/00/26	Q)Z 04Z
Offset/Setup					ົກ	aa. A a d)	14	108/21					052042
Process						water water,	ľ '	101					19100/21
Supplier						•							
Training													
Transport													
Unapproved		L	L		<u> </u>	127-347-11		HT CA	FECORY			<u> </u>	
Landi						General	FA	JET CA	TEGORY				
Lanui	lig (Bending				Bend		احمانه (د	Program	Г	Outside Dim	onsions F	Pressure/Forced
	-	Centre No	nt Concer	ntric	-	BOM/Route		Grain	Togram	<u> </u>	Over/Under		Set-up
		Cracks	or concer		-	Broken/Damage/Defect		Hardwa	are	H ²	Part Incorre	<u> </u>	Temperature/Cure
		Crimp/Kin	ık/Ripple	/Wave		Burrs		1	ion Incomplete/Un	gualified	Part Lost/M	}	Weld
		Cuffs		,	<u> </u>	Contamination		1	tions Incomplete/U	· —	Part Moved	 	Wrong Stock Pulled
,		Crushing			<u> </u>	Countersink		4	ned/off center	-	Positioned V	<u>L</u>	
		Heat Trea	t			Cut Too Short		Mislabe		<u> </u>	Power Loss/	· -	Other
		Inspection	n Strip in	Tube		Drawing		Misrea		L	······································		
		Marks/Ch	atter			Drill Holes		Off-set					
		Turning Se	equence			Finish		1	Calibration		····		
	П	Wave/Tw	ist in Tub	e	<u> </u>	Fit/Function		Out of	Sequence			** ** ** ***	

Work Ord June-16-14 1:		121092		*12	1092*							Page
Item ID: Revision ID:	D3417-5	5		Accept	*N900	<u>040</u>	100)*	Setup	Start Stop		S1*
Item Name: Start Date: Required Dat Reference:	Washer 7/15/14 e: 7/15/14	Start Qty: 24.00 Req'd Qty: 24.00	*24* *24*		Cust Item I	ID:	_		D			S2*
Approvals:	Process QC:	s Plan:	Date:	Tooling: SPC (Y/N):		ate: ate:			Run	Start Stop		R1* R <i>2</i> *
Sequence ID/ Work Center 130 *130*	ID	Operation Description Identify as per dwg & Sto	ock Location:	Set Up/ Run Hours 0.00	Tool ID	Tool#	Plan Code	Accept Qty	t Rej Qty		Reject Number	Insp. Stamp

140

QC21- Final Inspection - Work Order Release

0.00

0.00

140

Packaging

Packaging

QC

Memo

Memo

0.00

Quality Control

MLS 14-08-22

Page 2

DQA:		Date:	:											TRACT
QA Closed:		Date:	•		WORK ORDER NON-	-C(ONFO	RMANCE / UP		١٨/،	ork Order up	ndate only	_	AEROSPACE
QA CIOSCO.		Date	<u> </u>					···········	·			•	<u> </u>	
Work Orde	er:				DISPOSITION				AGAINST	DE	PARTMENT,	/PROCESS		
			<u></u> -		Rework			Skid-tube	Crosstube			Water Jet		Engineering
Part N	lo				Scrap			Machining	Small Fab		Pro	d. Eng. Coor.		Quality
					Use-as-is		Therr	moforming	Finishing		Rec/Sto	re/Packaging		Other
NCR N	10				Suspected Unapproved			Large Fab	Composite			Supplier		
Root				Desci	ription of work order update		Initial	Actio	on		Sign &		-	
Cause	Date	Step	Qty		or non-conformance	Ch	ief Eng	Descri	ption		Date	Verificatio	'n	QC Inspector
Design											-	-		
Doc/Data														
Equip/Tooling		·												
Handling/Pre														
Material	_													
Operator	_							,						
Offset/Setup														
Process											:			
Supplier	_											n		
Training	_													
Transport	_													
Unapproved			<u> </u>	L				<u> </u>				•		
l andi:	ng Gear					FA	ULI CA	TEGORY						
Lanun	Bendin	G			General Bend	Γ_	ادمانه رد	Program	[Outside Dim	onsians	\Box	Pressure/Forced
		ಕ Not Conce	ntric	-	BOM/Route		Grain	Togram		_	Outside Dim			Set-up
	Cracks	NOT COINCE	intric		Broken/Damage/Defect	┢	Hardwa	ara		-	Part Incorred		H	Temperature/Cure
		Kink/Ripple	e/Wave	-	Burrs	\vdash	1	ion Incomplete/Und	gualified	-	Part Lost/Mi			Weld
	Cuffs		-,		Contamination	\vdash	1 '	tions Incomplete/U	•	\vdash	Part Moved	331118	\vdash	Wrong Stock Pulled
	Crushir	ng			Countersink	<u> </u>	4	gned/off center		-	Positioned V	Vrong		The state of the s
	Heat Ti				Cut Too Short	\vdash	Mislabe			_	Power Loss/	-		Other
		ion Strip ir	n Tube	<u> </u>	Drawing '		Misread				1	3 -		<u> </u>
		Chatter			Drill Holes		Off-set							
		g Sequence	9		Finish		4	Calibration						
	Wave/	- Twist in Tu	he		Fit/Function	П	4	Saguence						

Picklist Print

June-16-14 1:18:11 PM

Work Order ID: 121092

121092

Parent Item:

D3417-5

D3417-5

Parent Item Name: Washer

Start Date: 7/15/14

Required Date: 7/15/14

Page 1

Start Qty: 24.00

Required Qty: 24.00

Comments:

IPP Rev:ANew issue08-07-09 JLM Verified By:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch		Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MDELRINR1.2500		Purchased	No			110	f	21.7200	0.0296	0.74779)	-, .	
*MDFI RII DELRIN ROUND BAR 1.2		10 *							**	14-	7-16	, <u>}</u>	Sp.

Location Loc Qty Loc Code 21.72 MAT

21.72 m128113

DQA:		Date:	:		•			_				TRACE	
QA Closed:		Date:	•		WORK ORDER NON	-C(ONFO	RMANCE / U		· Mark Ordon ·	ndoto only	AEROSPACE	
QA Closed.		Date	•			-				Work Order u	puace only		
Work Orde	er:				DISPOSITION				AGAINST	T DEPARTMENT/PROCESS			
		·····			Rework	1		Skid-tube	Crosstube	\neg	Water Jet	Engineering	
Part N	lo.				Scrap	1		Machining	Small Fab	Pro	od. Eng. Coor.	Quality	
					Use-as-is	1		noforming	Finishing		re/Packaging	Other	
NCR N	lo				Suspected Unapproved			Large Fab	Composite		Supplier		
Root				Desci	ription of work order update	Π	nitial	A	ction	Sign &			
Cause	Date	Step	Qty		or non-conformance	Ch	ief Eng	Des	cription	Date	Verification	QC Inspector	
Design `					··· · · - ·								
Doc/Data													
Equip/Tooling													
Handling/Pre													
Material													
Operator													
Offset/Setup	_												
Process													
Supplier													
Training													
Transport													
Unapproved													
						FAI	ULT CAT	TEGORY					
Landin	ng Gear			-	General		_		_				
	Bendin	g			Bend		Folio/F	rogram	٠	Outside Din	nensions	Pressure/Forced	
	Centre	Not Conce	ntric		BOM/Route		Grain			Over/Unde	tolerance	Set-up	
	Cracks				Broken/Damage/Defect		Hardwa	re		Part Incorre	cí	Temperature/Cure	
	Crimp/	Kink/Ripple	e/Wave		Burrs		Inspect	ion Incomplete/l	Unqualified	Part Lost/M	issing	Weld	
	Cuffs				Contamination		Instruct	ions Incomplete	/Unclear	Part Moved		Wrong Stock Pulled	
Į	Crushii	ng			Countersink		Misalig	ned/off center	r [Positioned	Wrong	_	
	Heat T	reat			Cut Too Short		Mislabe	eled	[Power Loss,	/Surge	Other	
Į	Inspect	tion Strip ir	1 Tube		Drawing		Misread	t l	_				
Į	Marks/	'Chatter			Drill Holes		Off-set						
	Turnin	g Sequence	<u> </u>		Finish		Out of 0	Calibration					
	Wave/	Twist in Tu	he		Fit/Function		Out of	Seguence		· · · · · · · · · · · · · · · · · · ·			

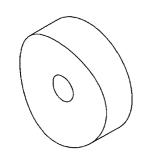
DART AEROSPACE LTD	Work Order:	121092
Description: Washer	Part Number:	D3417-5
Inspection Dwg: D3417 Rev: F		Page 1 of 1

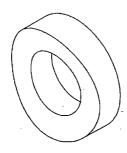
FIRST ARTICLE INSPECTION CHECKLIST

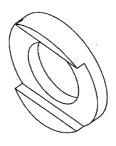
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø1.125	+0.030/-0.000	1.140	/			
Ø0.641	+0.008/-0.001	-643	/			
0.120	+0.010/-0.000	-127	//			
0.810	+0.010/-0.000	-814				
0.251	+/-0.010	.252	/			
R2.00	+/-0.030	R2-00				
	. :					
				, , , , , , , , , , , , , , , , , , , ,		
						-
			DA	C		

Measured by:	Audited by: 45	Preliminary Approval:
Date: 14-7-16	Date: 14/08/21	Date:

Rev	Date	Change	Revised by	Approved
Α	09.05.04	New Issue	KJ/DD	
В	10.11.12	Dwg Rev updated	KJ , Oc	
С	12.07.31	Dwg Rev updated	KJ 🚧	Chall









D3417-1 WASHER

D3417-3 WASHER

D3417-5 WASHER

D3417-7 WASHER

SHOP COPY

RETURN TO

ENGINEERING

UNCONTROLLED COPY

SUBJECT TO AMENDMENT

WITHOUT NOTICE

WORK ORDER NO. 12 10 97 MLJ

1406-17

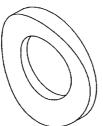
NOTES:

1) MATERIAL: BLACK DELRIN II 150E OR ACETRON GP ACETAL, ROD REF DART SPEC M-DELRIN-R
OR BLACK DELRIN II 150E OR ACETRON GP ACETAL, BAR REF DART SPEC M-DELRIN-B
OR BLACK DELRIN II 150E OR ACETRON GP ACETAL, SHEET REF DART SPEC M-DELRIN-S

2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: N/A
7) WEIGHT: D3417-1, 0.020 lbs
D3417-5, 0.010 lbs
D3417-7, 0.010 lbs
D3417-7, 0.004 lbs

С

D3417-9 WASHER



OFCION		00			
REV.			DESCRIPTION	BY	DATE
A	NEW IS	SUE		PH	05.03.31
В	CHANG	E TO ROUND V	VASHER	PH	05.06.10
¢	REMOV	E CBORE, WID	EN	PH	05.06.30
۵	ADD -5 & UPDA REASO	WASHER (ZN E TE TO CURRE N: INSTALLATION	32-1, B2-2); REFORMAT TO "B" SIZE NT STANDARDS; ON OF NEW TOW RING	AJS	08.07.08
E	ADD D3	417-7 (ZN A2-2)	RF .	09.06.30
F	ADD D3	3417-9 (ZN B5-3	}	SC	10.07.26

DESIGN	SC	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	SC		
CHECKED	5/	DRAWING NO.	REV. F
MFG. APPR.		D3417	SHEET 1 OF 3
APPROVED	-111	TITLE	SCALE
DE APPR.	-##	WASHER	NTS
DATE 10.07.26		COPYRIGHT © 2005 BY DART AEROSPACE LTD THE DOLLET A MENATA MD CONFIDENTIAL MD 6 SUPPLED ON THE EXPRESS CONGITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR CONCESSED AS CONSECUTED TO THEM PERSON WITHOUT	

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